

Work Order ID 110801

January-07-14 3:03:49 PM

110801

Page 1

Item ID: D3404-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: GHW/ Lug

Stop

NS2

Start Date: 1/07/14 Start Qty: 60.00

60

Cust Item ID:

Required Date: 1/07/14 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 14-01-08

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3404	Rev C

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

51

J

14-02-23

Memo

0.00

Cut blank: 2.700" long

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Fk 14/02/25

51

P

14-02-23

Memo

0.00

1-Machine as per Folio FA555 and Dwg D3404Dwg Rev: C Folio Rev:

AA 2-Deburr

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Fk 14/02/25

51

P

14-02-23

Memo

0.00

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	Bending	General	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric		Grain	Over/Under tolerance	Set-up
	Cracks		Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs		Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing		Misaligned/off center	Positioned Wrong	
	Heat Treat		Mislabeled	Power Loss/Surge	Other
	Inspection Strip in Tube		Misread		
	Marks/Chatter		Off-set		
	Turning Sequence		Out of Calibration		
	Wave/Twist in Tube		Out of Sequence		

Work Order ID 110801

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Page 2

Item ID: D3404-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: GHW/ Lug

Stop

NS2

Start Date: 1/07/14 **Start Qty:** 60.00

60

Cust Item ID:

Required Date: 1/07/14 **Req'd Qty:** 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

14/02/26

57 8

140

Identify as per dwg & Stock Location: WAOO1 0.00

140

Packaging

Packaging

0.00

57 14-2-27

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Quality Control

0.00

MJ 14-02-28

AD 14-02-27

DAS
26
9-89

DQA:

Date:



QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No.				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering			
NCR No.				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other			
				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>							
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>							
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>							
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>									
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>									
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									

Picklist Print

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Page 1

Work Order ID:	110801	Start Date:	1/07/14	Required Date:	1/07/14
Parent Item:	D3404-1	Start Qty:	60.00	Required Qty:	60.00
Parent Item Name:	GHW/ Lug				
Comments:	IPP Rev:A05.09.01New issueKJ/JLM IPP rev B 09.01.28 new geometry rev.C	EC verified by:DD			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500 304 BAR .750 X 2.50		Purchased	No			100	f	0.0000	0.2291	14.469474		DR	

+27582

M304 128085
.750 X 2.500

12 ft.

14-02-23

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
Scrap
Use-as-is
Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
Machining
Thermoforming
Large Fab

Crosstube
Small Fab
Finishing
Composite

Water Jet
Prod. Eng. Coor.
Rec/Store/Packaging
Supplier

Engineering
Quality
Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
		Bending	Bend	Folio/Program	Outside Dimensions				Pressure/Forced		
		Centre Not Concentric	BOM/Route	Grain					Set-up		
		Cracks	Broken/Damage/Defect	Hardware					Temperature/Cure		
		Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified					Weld		
		Cuffs	Contamination	Instructions Incomplete/Unclear					Wrong Stock Pulled		
		Crushing	Countersink	Misaligned/off center							
		Heat Treat	Cut Too Short	Mislabeled					Power Loss/Surge		
		Inspection Strip in Tube	Drawing	Misread							
		Marks/Chatter	Drill Holes	Off-set							
		Turning Sequence	Finish	Out of Calibration							
		Wave/Twist in Tube	Fit/Function	Out of Sequence							

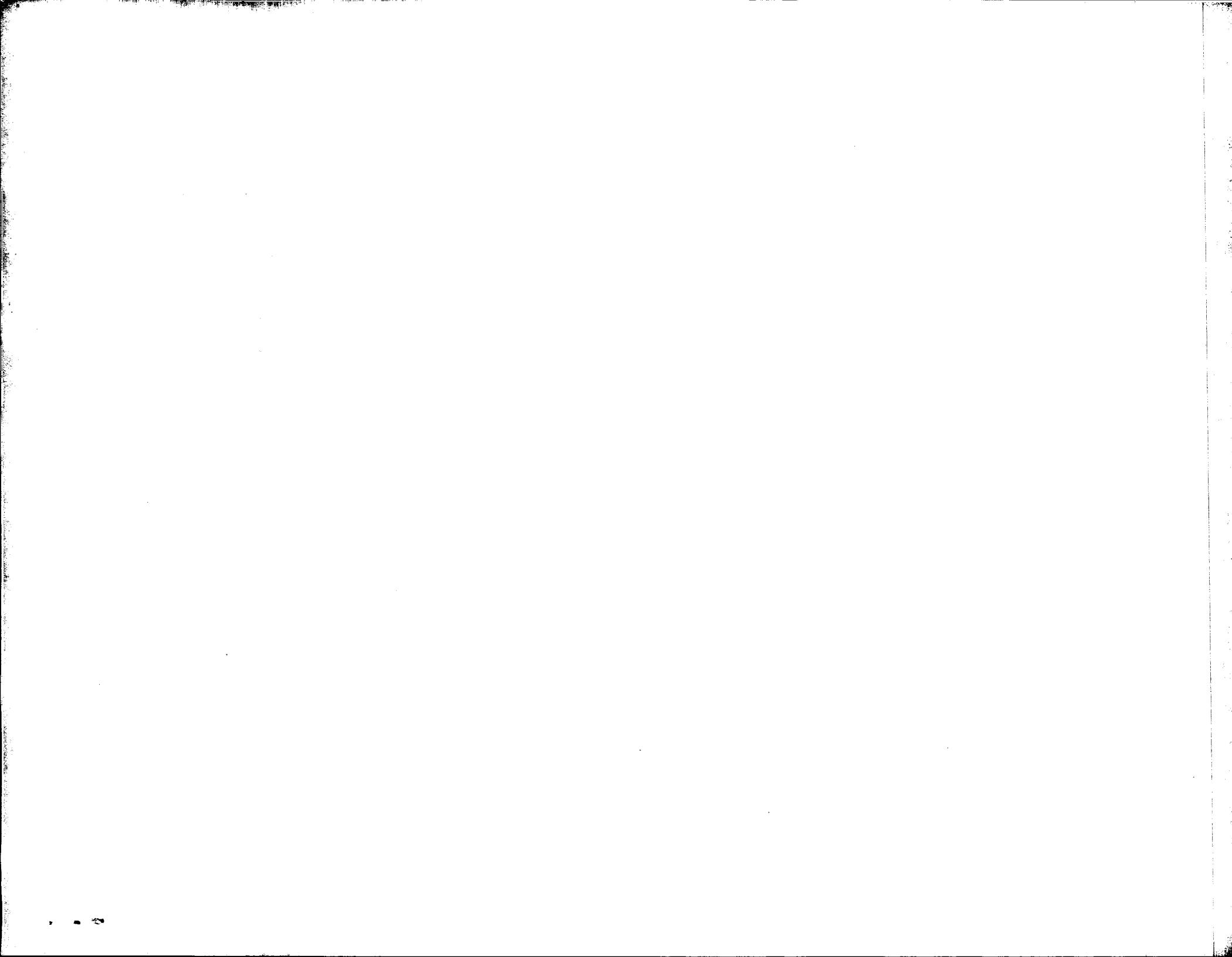
DART AEROSPACE LTD	Work Order:	110801
Description: GHW Lug	Part Number:	D3404-1
Inspection Dwg: D3404	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

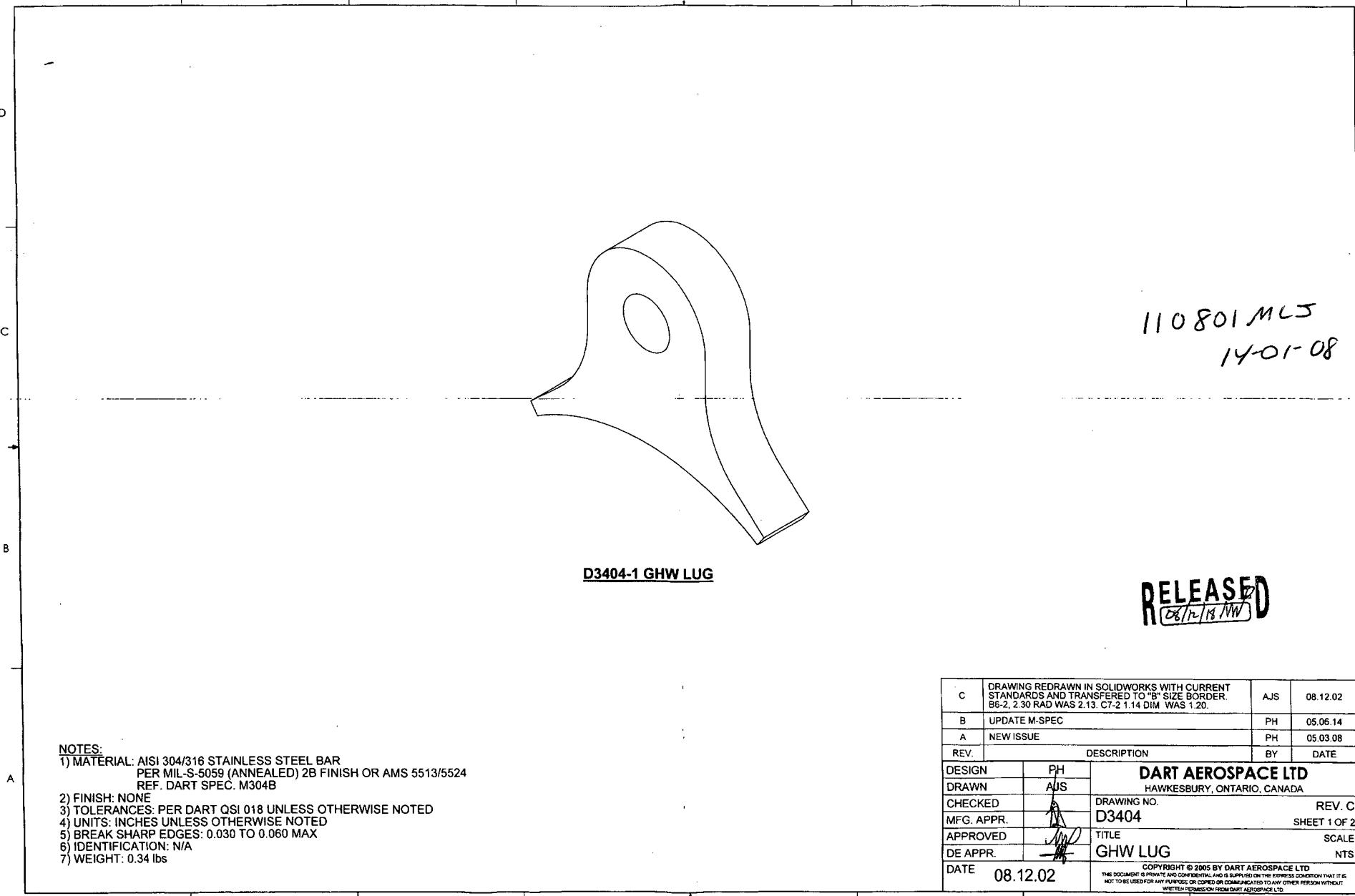
X First Article Prototype

Measured by:	<u>D.P / F.K</u>	Audited by:	<u>One</u>	Prototype Approval:	N/A
Date:	14-02-23	Date:	14/02/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.12	New Issue	KJ/JLM	
B	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD	



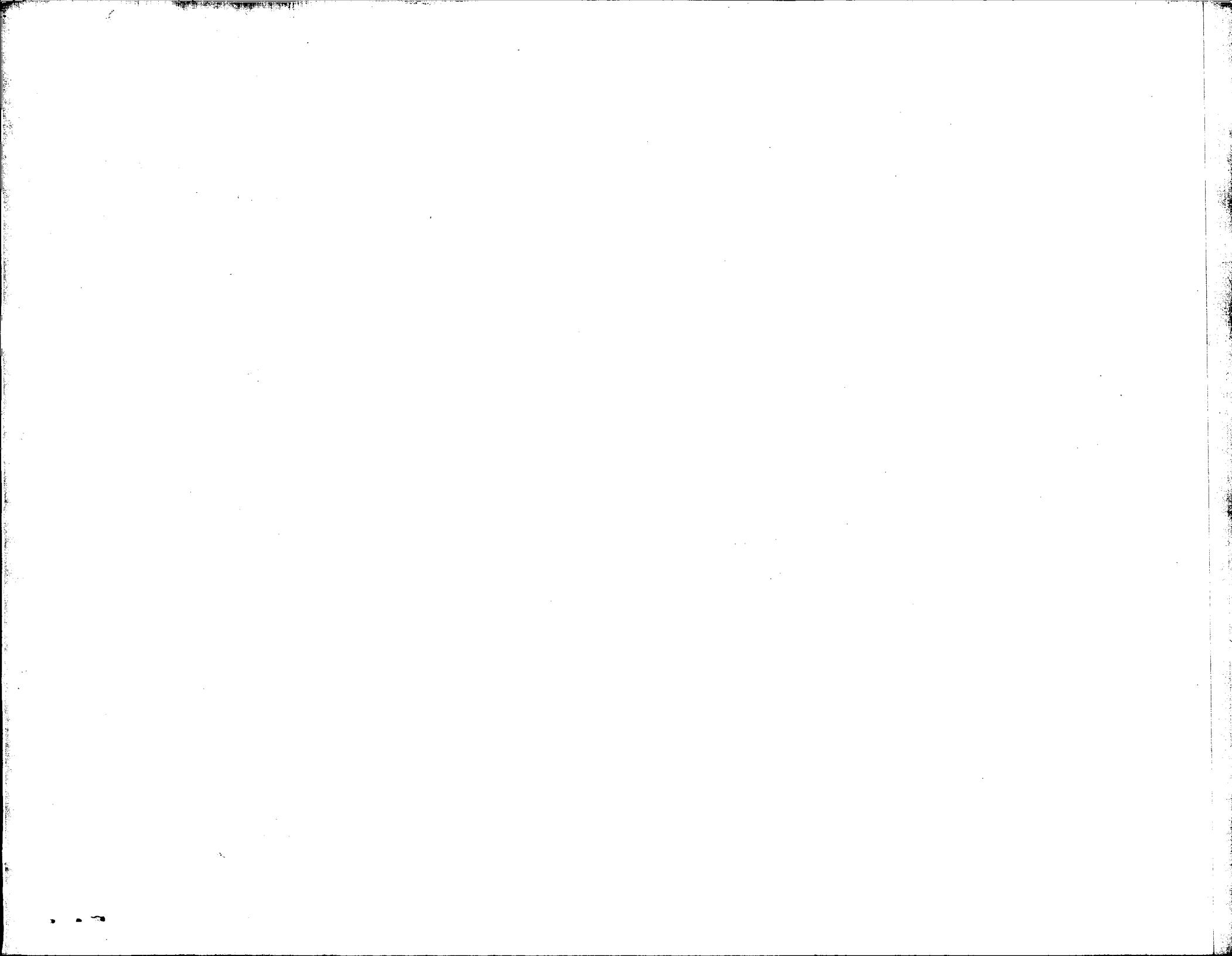
8 7 6 5 4 3 2 1

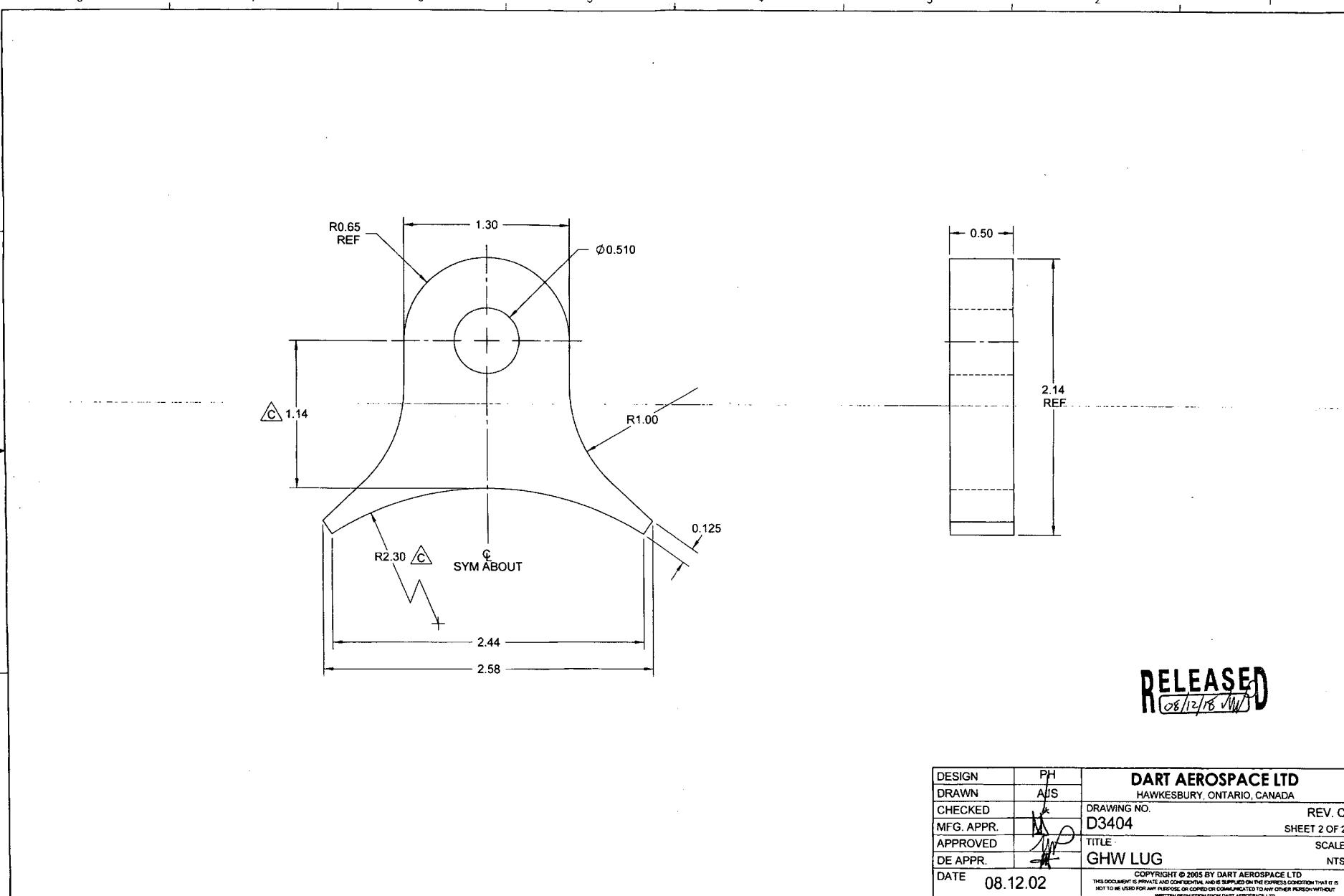


NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

8 7 6 5 4 3 2 1





RELEASED
08/12/16 MW

DESIGN	PH	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3404
APPROVED		REV. C
DE APPR.		SHEET 2 OF 2
DATE	08.12.02	TITLE
		GHW LUG
		SCALE
		NTS
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